

# Work Order ID 63695

November 10, 2010 10:25:20 AM



Page 1

Item ID: D2858-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 11/10/10 Start Qty: 20.00



Cust Item ID:

Required Date: 11/26/10 Req'd Qty: 20:00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 10/11/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2858	Rev B

100.

0.00



BAND SAW

0.00

Bandsaw

Memo

Jeaspa Bandsaw

Cut blanks 5.850  
" Note: 1 Blank Makes 3 Parts

SL 10/11/10

(7)

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine per folio FA941  
FOLIO REV: 3  
DWG REV: 3  
2-Deburr any rough edges

SL 10/12/08

(21)

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

SL 10/12/08

(21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		10/12/09		(21)			
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00		=> 10/12/09		21	0		
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: 10:55 3:00 FINISH TIME: 11:05	0.00 0.00				21		BL 10-12-13.	

OVEN TEMPERATURE: 11:05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63695**

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Item ID: D2858-1

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Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 11/10/10 Start Qty: 20.00



Cust Item ID:

Required Date: 11/26/10 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

=) *ll*

10/12/13

21

*q*

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: *025*

0.00



Packaging

Memo

0.00

Packaging

*10/12/13 (21)*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*CK*

10/12/13

*MF*

10-12-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

November 10, 2010 10:25:20 AM

Page 1

Work Order ID: 63695

Parent Item: D2858-1

Parent Item Name: Hinge Bracket



Start Date: 11/10/10

Required Date: 11/26/10

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP ☐ C00.06.22 ☐ Removed P/O for powder coat ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased	No			100	f	37.7860	0.163	3.431579			



6061-T6 Bar 1.50 x 1.25



SL 10/11/10

Location

Loc Qty

Loc Code

MAT10

37.78595

107461

11.26315

110936

26.5228

- 3.5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

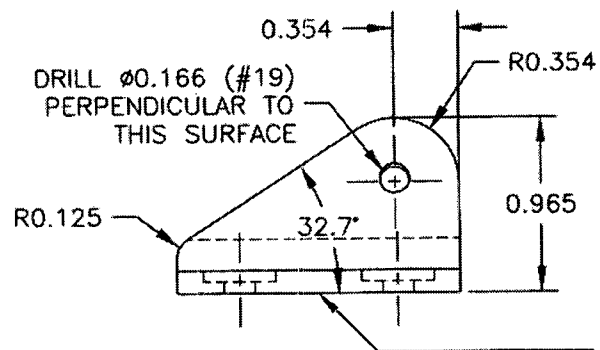
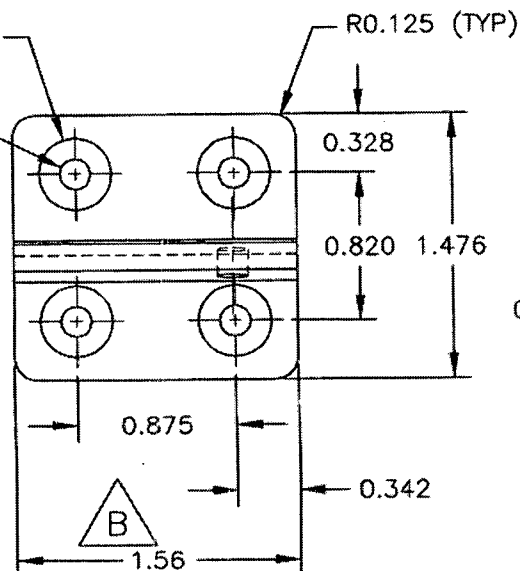
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Ø0.400 C'BORE TO  
LEAVE 0.063  
(TYP 4 PLACES)

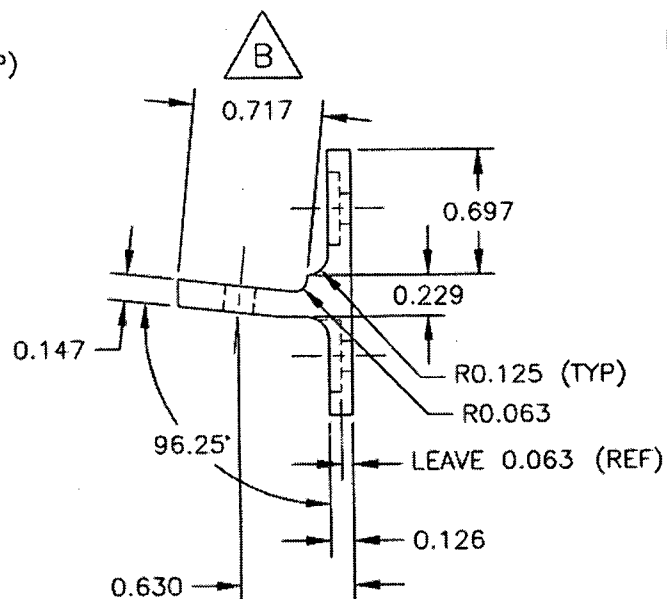
Ø0.171  
(TYP 4 PLACES)



ENGRAVE P/N CENTERED ON  
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN  
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASED  
99.02.28 KE

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HANKESSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
UP	KE	D2858
DATE	TITLE	SHEET 1 OF 1
99.02.28	HINGE BRACKET	SCALE 1:1
A	98.12.14	NEW ISSUE
B	99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 63695
<b>Description:</b> hinge bracket		<b>Part Number:</b> 12858-1
<b>Inspection Dwg:</b> 12858 Rev: B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.400	$\pm .010$	.402	✓		Rm J-3	
Ø.171	$\pm .005$	.173	✓		"	
.875	$\pm .010$	.875	✓		"	
1.56	$\pm .030$	1.570	✓		"	
.342	$\pm .010$	.347	✓		"	
1.476	$\pm .010$	1.480	✓		"	
.820	$\pm .010$	.820	✓		"	
.328	$\pm .010$	.330	✓			
Ø.125	$\pm .010$	.125	✓		R-G	
.354	$\pm .010$	.354	✓		Van J-3	
Ø.166	$\pm .005$	.167	✓		"	
Ø.125	$\pm .010$	.125	✓		R-G	
.965	$\pm .010$	.966	✓		"	
.147	$\pm .010$	.148	✓		"	
.717	$\pm .010$	.723	✓		"	
.630	$\pm .010$	.630	✓		"	
.126	$\pm .010$	.126	✓			
.063	$\pm .010$	.063	✓			
Ø.063	$\pm .010$	.063	✓			
Ø.125	$\pm .010$	.125	✓			
.229	$\pm .010$	.232	✓			
.697	$\pm .010$	.697	✓			

<b>Measured by:</b> J.L.	<b>Audited by:</b> M.A.	<b>Preliminary Approval:</b>
<b>Date:</b> 10/12/08	<b>Date:</b> 10/12/09	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15